

Work Order ID 83986

83986

Page 1

Tuesday, May 01, 2012 8:47:37 AM

Item ID: D3943-053 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chain Assembly
 Start Date: 5/1/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 5/11/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: ymf Date: 12-05-01 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3943	E

100 Weld per dwg A/R Steel rod Batch: M114509 0.00
 100 Large Fab Memo 0.00
 Large Fab ASSEMBLE WITH CHAIN BEFORE WELDING

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110 QC Memo 0.00
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
 120 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Hybrid safety Yellow 4.3.5.12	0.00				5X	0		Mick 12/25/04
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130

Powdercoat

Powder Coating

Memo

0.00

1- MASK CHAIN FROM THIS POINT ON PRIOR TO powdercoat AS PER DWG

2- POWDER COAT: 7:50

Start Time: 32

Oven Temperature: 400°F

Finish Time: 8:20

140

140

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: w/a

0.00

Memo

0.00

(5) 12-5-10

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/1/2012 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 5/11/2012 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/5/10 *[Signature]*

MF
12-05-10

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Picklist Print

Tuesday, May 01, 2012 8:47:36 AM

Page 1

Work Order ID: 83986

Parent Item: D3943-053

Parent Item Name: Chain Assembly

Start Date: 5/1/2012

Required Date: 5/11/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP RevA: add DEO DD 09.11.18 verified by:JLM IPP Rev:B as per dwg REV.C DD
10.02.22 verified by:EC IPP rev C 11.05.24 ECN 11-578 ec verified by:DD IPP
REV:D 11.08.16 AS PER REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3954-5 Chain Lug		Manufactured	No			100	Each	5.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		5							
				71173		5							
D3954-9 GWT Chain Pin		Manufactured	No			100	Each	19.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST075		19							
				71876		19							
D4405-1 Eye and Fork Swivel		Manufactured	No			100	Each	9.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		9							
				70986		5							
				78913		4							

Added on
D3943-04

Dart Aerospace Ltd

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS

E	CHANGED D3945-3 MATL TO SS (B8-5); FINISH NOW "NONE" (A7-5); TAP DRILL FOR 1/4-20 UNF-28 WAS PILOT HOLE NOTE (B1-5). PER PART11-113.	MB	11.07.27
D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED), SHT 2 ZN D3 FLAG RELOCATED, SHT 3 ZONE D3, Ø.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTON / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. E
CHECKED	ASS	D3943	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		GROSS WEIGHT TOW CRANK ASSY	NTS
DE APPR.	N/A	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	11.07.27		

RELEASED
2011-07-29

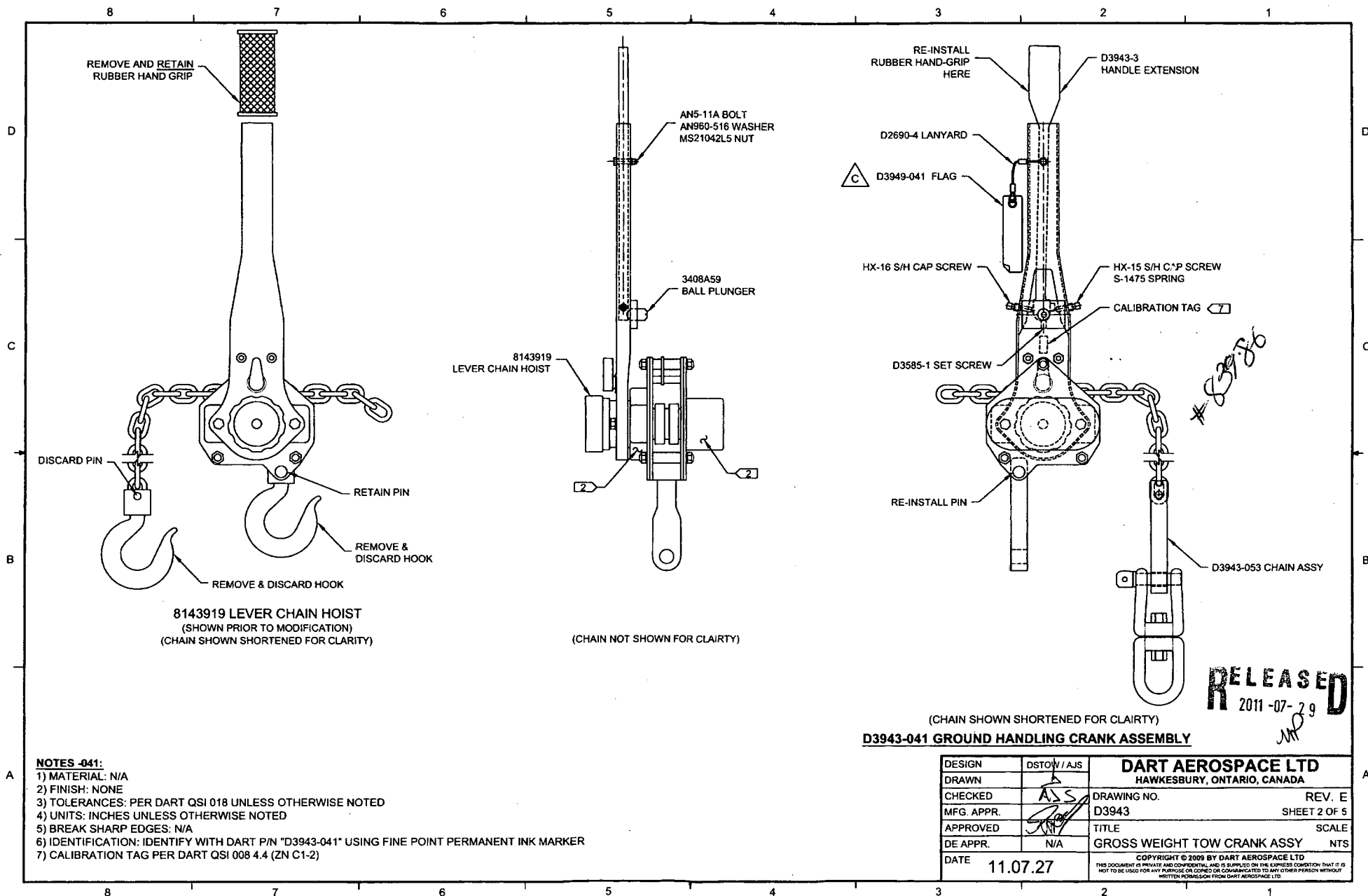
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Dart Aerospace Ltd

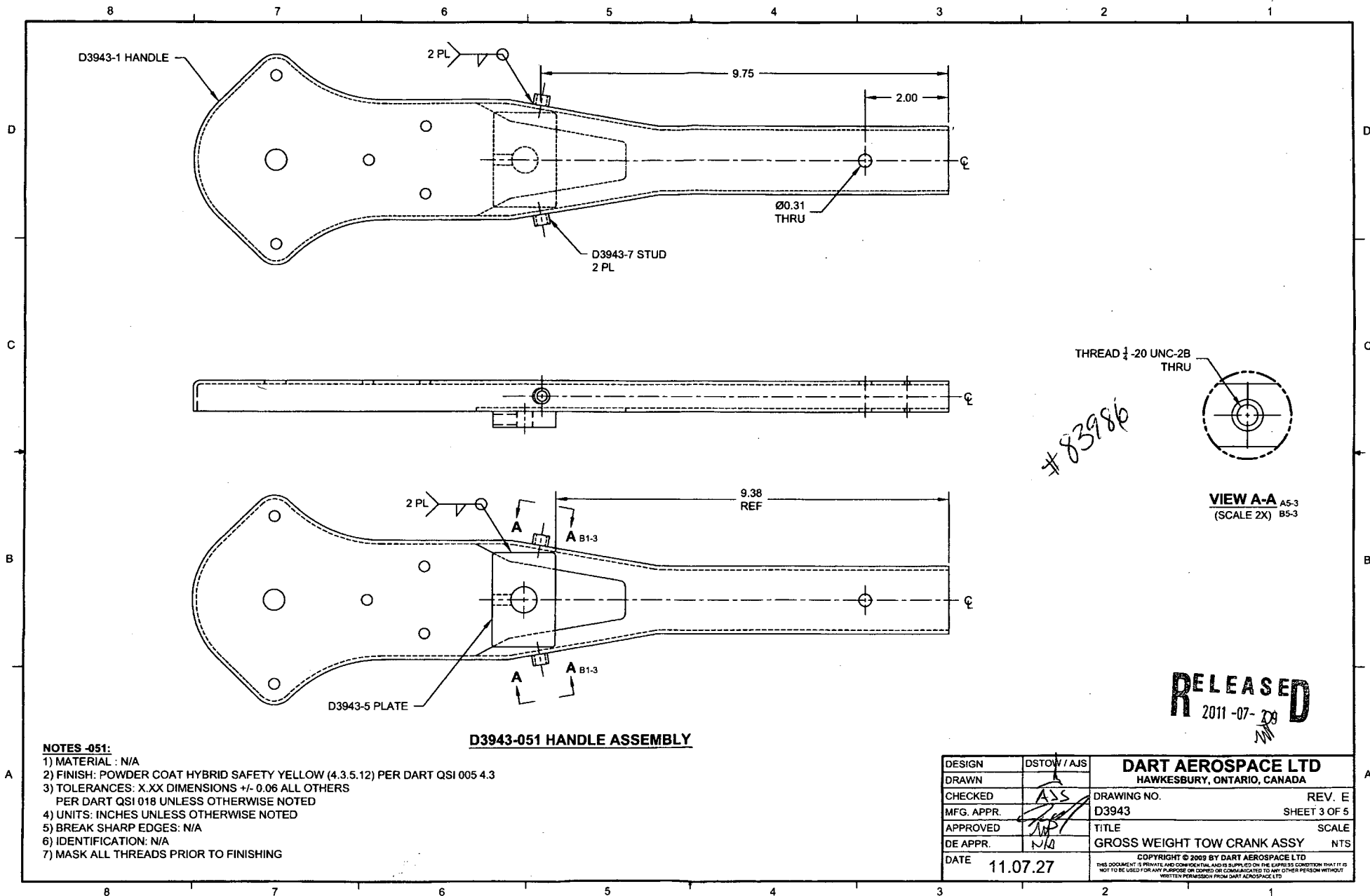
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- NOTES -051:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
 - 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) MASK ALL THREADS PRIOR TO FINISHING

D3943-051 HANDLE ASSEMBLY

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
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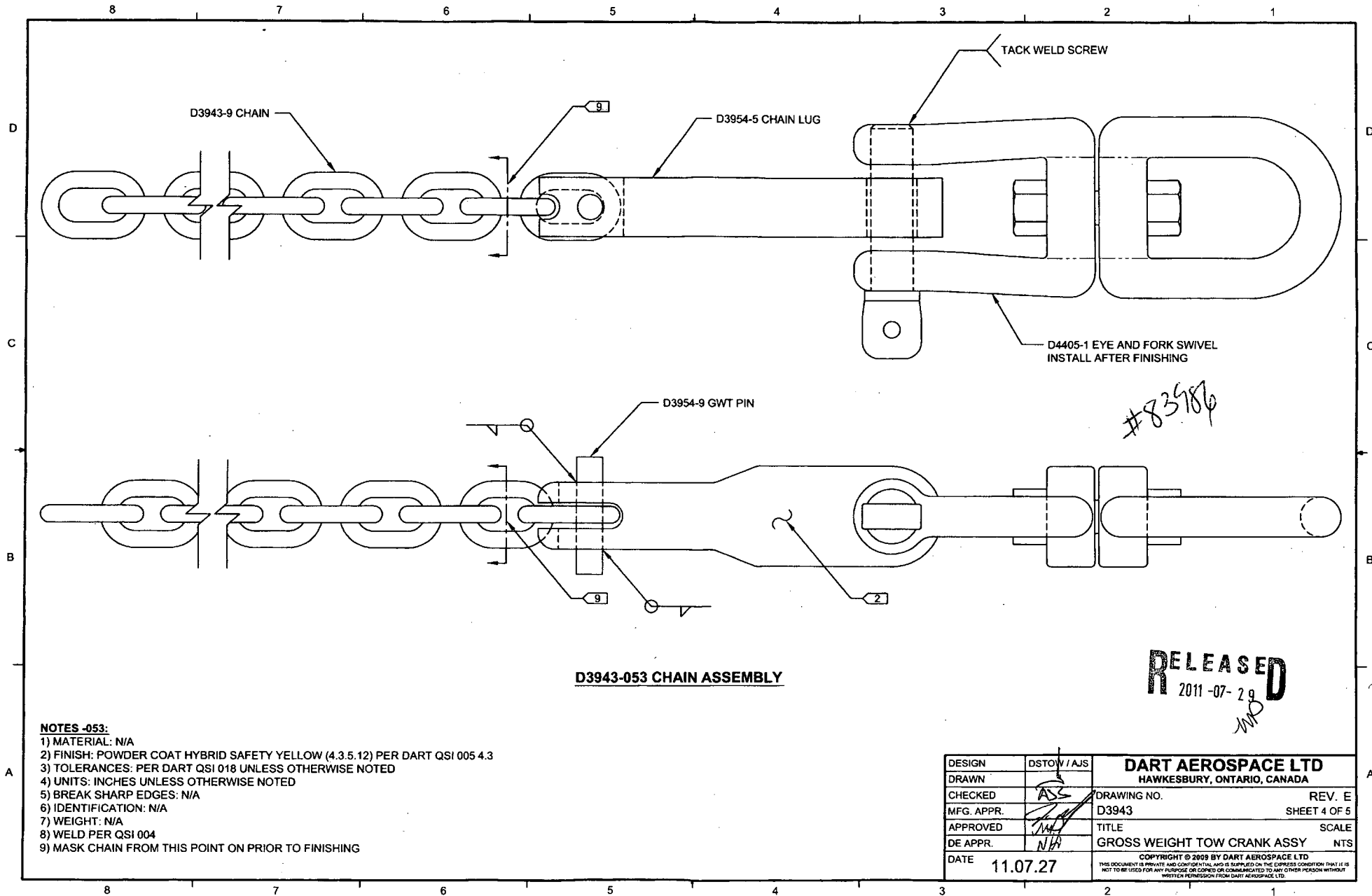
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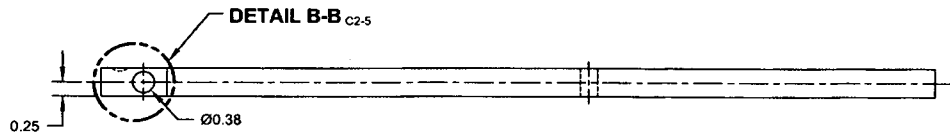
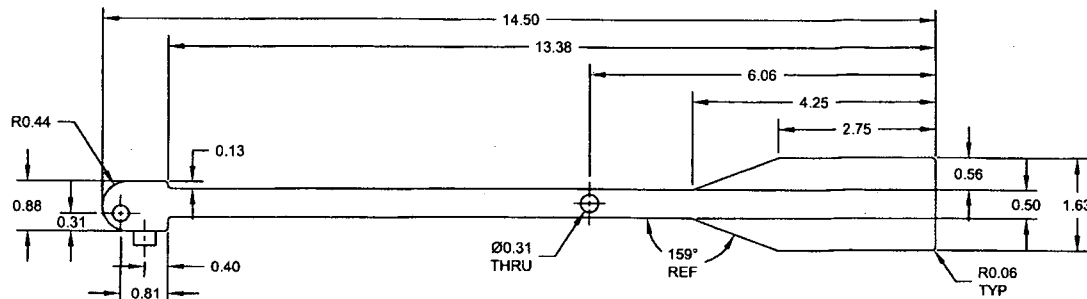
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

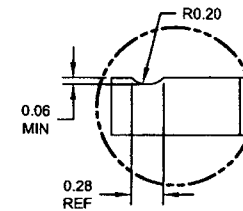
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8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION



DETAIL B-B C7.5
(DIMPLE DETAIL)
(SCALE 2X)

NOTES:

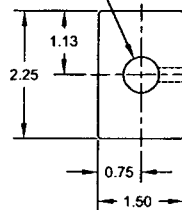
1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

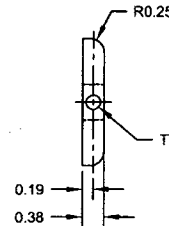
-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

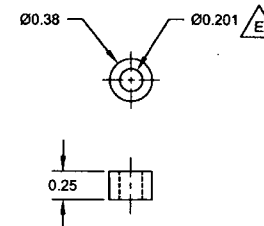
THREAD $\frac{1}{8}$ -11 UNC-2B



D3943-5 PLATE



THREAD $\frac{1}{8}$ -28 UNF-2B



D3943-7 STUD
(SCALE 2X)

RELEASED
2011-07-28
NO

DESIGN	DSTOW/AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 5 OF 5
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8 7 6 5 4 3 2 1

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